



Jefferson Lab Alignment Group

Data Transmittal

TO: J. Preble, B. Carpenter

DATE : Oct 10, 2003

FROM: J. Dahlberg

Checked:

Z902

DETAILS:

Below are the results from the recent inspection performed on the SNS cryomodule offset fixtures. A 4.889" dia. flange bolted to the contact pads was used to set the origin and the level vial contact pad was used to set rotation. The X and Y values are offsets between the center flange used for the origin and the 2.25" dia. target placed on the outer V-groove. A +X is greater than the 36.5000" nominal offset and a +Y is above center.

	X	Y
FIX. #1		
Old	+ 0.0035"	- 0.0023"
New	+ 0.0045"	- 0.0022"
Delta	+ 0.0010"	+ 0.0001"
FIX. #2		
Old	+ 0.0046"	- 0.0040"
New	+ 0.0060"	- 0.0077"
Delta	+ 0.0014"	- 0.0037"
FIX. #3		
Old	- 0.0030"	+ 0.0115"
New	+ 0.0021"	+ 0.0117"
Delta	+ 0.0051"	+ 0.0002"
FIX. #4		
Old	- 0.0030"	+ 0.0062"
New	- 0.0028"	+ 0.0064"
Delta	+ 0.0002"	+ 0.0002"